

**Garant**
**Milling insert for external threads 60°, Carbide, Pitch: 4mm**

**Order data**

Order number	218074 4
GTIN	4045197447609
Item class	21D

**Description**
**Version:**

**Sturdy** milling inserts for **high feed rates** and **high productivity**.

Double-edged

**Application:**

**For metric external threads 60°** to DIN / ISO R 262 (DIN 13) tolerance class 6g.

**Note:**

Always fit the thread milling inserts with the marks matching, otherwise the thread will be distorted! (Sides have either a mark or no mark).

Feed  $f_z = \text{HB 7720 in steel} < 750 \text{ N/mm}^2 = 0.25 \text{ mm / tooth}$ .

Feed  $f_z = \text{HB 7735 in INOX} > 900 \text{ N/mm}^2 = 0.15 \text{ mm / tooth}$ .

Cutting direction: right-hand and left-hand

Insert size: 41 mm

**Technical description**

Internal/external application	External
Full profile	yes

Coating	TiAlN
Thread pitch	4 mm
suitable for threads	M36; M39
Number of cutting edges Z	10
Grade	HB7735
Tool material	Carbide
Thread type	M
Thread type	MF-LH
Thread type	M-LH
Thread type	MF
Flank angle	60 °
Insert size	41 mm
Cutting direction	right-hand and left-hand
Type of product	Cutter insert for milling

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	110 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	25 m/min	H
Steel < 60 HRC	suitable only under restricted conditions	20 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M
GG(G)	suitable	70 m/min	K
CuZn	suitable only under restricted conditions	120 m/min	N
Oil	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable only under restricted conditions		